

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Internal Transport ☐	Use for Testing ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Tribal Knowledge ☐	Poor Information ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Work Order ID 136304

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136304

Page 2

Item ID: D412-711-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Reference Door Modification LH

Stop

NS2

Start Date: 9/1/2015

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/8/2015

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-711-021

Location:

PPP rev:

Ship

DAG
6
9-89

SEP 14 2015

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS

SEP 14 2015

(H) 15-9-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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Page 1

Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC
14.04.25 ECN14-548 DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-011 *D4324-011* Armrest Assembly		Manufactured	No				Each	1.0000	**	1		DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST459				1					
				118945				1					
D412-761-043 *D412-761-043* Modified Latch Mechanism, LH		Manufactured	No			120	Each	0.0000	**	1		DAS 27 9-89	DAS 26 9-89
D412-711-101 *D412-711-101* Replacement Vertical Reference Window		Manufactured	No			120	Each	1.0000	**	1		DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG100				1					
				117050				1					
D3802-1-120 *D3802-1-120* Window Seal - 120"		Manufactured	No			120	Each	5.0000	**	1		DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST421				5					
				114395				5					

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

D4165-1

Manufactured No

120 Each

3.0000

1 1

D4165-1

Doubler

DAS
6
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST246

3

115110

3

D4165-3

Manufactured No

120 Each

2.0000

1 1

D4165-3

Inner Door Panel

DAS
6
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

st238

2

116600

2

D4165-5

Manufactured No

120 Each

1.0000

1 1

D4165-5

Aft Rib

DAS
6
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST246

1

116601

1

D4165-7

Manufactured No

120 Each

17.0000

1 1

D4165-7

Fwd Rib

DAS
6
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST246

17

114255

6

116604

11

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

D4165-9

Manufactured No

120 Each

9.0000

1

D4165-9

Angle

DAS
6
9-89

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

ST259

9

117148

2

119607

7

D4165-11

Manufactured No

120 Each

4.0000

1

D4165-11

Door Cover Panel

DAS
6
9-89

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

ST258

4

125784

4

D4207-1

Manufactured No

120 Each

2.0000

1

D4207-1

Window Retainer

DAS
6
9-89

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

ST237

2

116606

2

D4207-3

Manufactured No

120 Each

3.0000

1

D4207-3

Instrument Window

DAS
6
9-89

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

ST237

3

116607

3

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

D4269-1 Manufactured No

120 Each

3.0000

1

D4269-1

Angle

DAS
6
9-89

Location

Loc Qty

Loc Code

ST097

3

123643

3

120 Each

2.0000

1

D4269-3

Manufactured No

D4269-3

Angle

DAS
6
9-89

Location

Loc Qty

Loc Code

ST097

2

127902

2

120 Each

5.0000

1

D4269-5

Manufactured No

D4269-5

Angle

DAS
6
9-89

Location

Loc Qty

Loc Code

ST258

5

134700

5

120 Each

8.0000

1

D4269-7

Manufactured No

D4269-7

Angle

DAS
6
9-89

Location

Loc Qty

Loc Code

ST258

8

132994

8

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

D4327-1
D4327-1
Angle

Manufactured No

120 Each

4.0000

1 1
**

DAS 26 9-89
27 9-89

Location

Loc Qty

Loc Code

ST259

4

113726

1

123687

3

D4327-3
D4327-3
Angle

Manufactured No

120 Each

4.0000

1 1
**

DAS 26 9-89
27 9-89

Location

Loc Qty

Loc Code

ST259

4

117081

4

D4385-1
D4385-1
Placard
AN3-3A

Manufactured No

120 Each

0.0000

2 2

DAS 26 9-89
27 9-89

Purchased No

120 Each

307.0000

22 22

DAS 26 9-89
27 9-89

AN3-3A
Bolt

Location

Loc Qty

Loc Code

ST338a

200

m131624

200

ST350

107

m132317

107

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DAS 26 9-89

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-4A

Purchased

No

120

Each

188.0000

20

20

AN3-4A

Bolt

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

CA

110

m129682

110

ST350

78

m132317

28

m133064

50

AN3-6A

Purchased

No

120

Each

194.0000

26

26

AN3-6A

Bolt

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

ST338a

100

M131305

100

ST349

94

M133064

94

AN3-12A

Purchased

No

120

Each

88.0000

1

AN3-12A

Bolt

**

DAS

DAS

27

26

9-89

9-89

Location

Loc Qty

Loc Code

GA

44

m129682

44

ST349

44

m133064

44

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

120

Each

2,017.000

92

92

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	210	
122063	210	
ST260a	1714	
m128401	6	
m131026	80	
m131697	628	
m133077	1000	
st268	93	
123900	7	
m130388	86	

DAS
26
9-89

CR3242-4-2

Purchased

No

120

Each

149.0000

34

34

CR3242-4-2

RIVET

DAS
6
9-89

Location

Loc Qty

Loc Code

ccr003	49	
m131340	49	
ST317	100	
m133077	100	

DAS
27
9-89

MS20426AD3-3

Purchased

No

120

Each

3,628.000

135

135

MS20426AD3-3

RIVET

DAS
6
9-89

Location

Loc Qty

Loc Code

ST313	3628	
M131624	3628	

DAS
26
9-89
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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-3

Purchased

No

120

Each

2,976.000

140

140

MS20426AD4-3

Rivet

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1176

113064

176

m125807

1000

ST312

1800

m125807

1800

**

DAS
27
9-89

DAS
26
9-89

MS20470AD3-3

Purchased

No

120

Each

6,609.000

25

25

MS20470AD3-3

RIVET, UNIVERSAL HEAD

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

989

1065

989

ST311

5620

16941

5620

**

DAS
27
9-89

DAS
26
9-89

MS20470AD4-3

Purchased

No

120

Each

1,711.000

90

90

MS20470AD4-3

Rivet - Universal Head

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

893

2193

893

ST310

818

2193

818

**

DAS
27
9-89

DAS
26
9-89

SEP 02 2015

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

1,069.000

24 24

MS21042L3

Nut

**

DAS

27

9-89

DAS

26

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

233

M131317

233

ST305

452

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

353

MS21059L3

Purchased

No

120

Each

155.0000

4 4

MS21059L3

Nut Plate

**

DAS

27

9-89

DAS

26

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

21

113749

1

M132677

20

ST303

118

M131616

18

M133016

50

M133031

50

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Work Order ID: 136304

136304

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 9/1/2015

Required Date: 9/8/2015

Start Qty: 1.00

Required Qty: 1.00

MS21069L3

Purchased

No

120

Each

99.0000

34 34

MS21069L3

ANCHOR NUT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST301

99

m131618

18

m133019

81

34

MS21069L08

Purchased

No

120

Each

656.0000

8 8

MS21069L08

ANCHOR NUT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST301

656

123522

656

8

MS21071L3

Purchased

No

120

Each

259.0000

3 3

MS21071L3

ANCHOR NUT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST301

259

114348

5

124291

50

125654

100

m129702

104

3

MS21071L08

Purchased

No

120

Each

164.0000

1 1

MS21071L08

ANCHOR NUT

DAS
6
9-89

Location

Loc Qty

Loc Code

ST301

164

102587

64

103447

100

1

DAS
26
9-89

DAS
26
9-89

DAS
26
9-89

DAS
26
9-89

SEP 02 2015

DAS

3
8-00

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
A1	A1	A1	A1	A1		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-741-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		*D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		**D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469-14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		*D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		**D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		**D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		*D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY
 ** PART OF EA20469-12 FWD RIB ASSEMBLY

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. K
MFG. APPR.	JLM	D412-711	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR NTS	
DATE 14.04.07		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
						1	204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1							D412-711-111	WIRING HARNESS, 212/412
B ₁							D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B ₁						D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B ₁					EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B ₁				EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B ₁			D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041.
(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210/214 Wiring Harnesses, use drawing D2046904.
For Bell 212 Wiring Harnesses, use drawing D2046903.
For Bell 412 Wiring Harnesses, use drawing D412-711-901.
For Bell 212 modified per SH07-28/SR02831NY use D212-761-224
or D212-761-225 depending on aircraft s/n.
* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft
serial numbers

Wiring Harnesses will vary
depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. K
MFG. APPR.	JLM	D412-711	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
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